








Work Order ID 59530

Page 1

Monday, June 07, 2010 10:30:48 AM

Item ID: D3908-041 Accept  Setup Start 
Revision ID:
Item Name: Crosstube Lug Assembly, Aft Stop 
Start Date: 6/7/2010 Start Qty: 5.00  Cust Item ID:
Required Date: 6/9/2010 Req'd Qty: 5.00  Customer:
Reference: REWORK TO NEW DRAWING REV C

Approvals: Process Plan: MF Date: 0-6-7 Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3908	C								

100	Pick Kit	0.00
-----	----------	------



Packaging

Memo

0.00

Packaging

PULL FROM STOCK D3908-041 X 5
B 58502MF 10-6-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries



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Item ID: D3908-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: Crosstube Lug Assembly, Aft
Start Date: 6/7/2010 Start Qty: 5.00  Cust Item ID:
Required Date: 6/9/2010 Req'd Qty: 5.00  Customer:
Reference: REWORK TO NEW DRAWING REV C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110  Small Fab		0.00							
Small Fab	Memo	0.00							
	1- REMOVE D3908-1 LUG PLATES X 2 PER KIT AND REPLACE WITH NEW D3908-1 B59343 REV C								
	2-REPLACE 1 X D3910-1 MOUNTING LUG WITH D4091-1								
	3-REPLACE ANY HARDWARE IF NECESSARY - scrap hardware that we replaced								
	4-LEAVE THE REMAINING LEFTOVER PARTS IN A BOX WITH RED TAG - MK 10-6-8								
	MEL WILL MAKE AN ADJUSTMENT FOR THE PARTS THAT ARE GOOD TO BE PUT BACK IN STOCK								
	WILL RED TAG THE REMAINING D3908-1 UNDER REV B UNTIL FURTHER NOTICE								
120  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							

Handwritten notes:
EP 10/06/08 (5)
D3910-1 B^{SP} 57194x6
- MK 10-6-8.
S106608
(45)

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Work Order ID 59530

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Item ID: D3908-041

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug Assembly, Aft

Stop



Start Date: 6/7/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 6/9/2010 Req'd Qty: 5.00



Customer:

Reference: REWORK TO NEW DRAWING REV C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 5503

0.00



Packaging

Memo

0.00

Packaging

ID AND STOCK UNDER NEW BATCH NUMBER

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/10

MF
10-6-9

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Picklist Print

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Page 1

Work Order ID: 59530

Parent Item: D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft





Comments: IPP RevA: New issue DD verified by:EC
As per Rev B 10-04-06 VERIFIED BY:DD
10.05.27 DD verf:EC
10.05.28 DD verf:EC
IPP REV B:
IPP Rev:C as per PC1
IPP Rev:D per ECN10-581

Start Date: 6/7/2010

Required Date: 6/9/2010

Start Qty: 5.00

Required Qty: 5.00

D2690-6	Manufactured	No	100	Each	16.0000	1	5
							
Lanyard Assembly							
<div><div><i>N</i></div><div><i>mf</i></div><div><i>10-6-9</i></div></div>							
	<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
	ST021		16				
	58375		16				
D3908-1	Manufactured	No	100	Each	23.0000	2	10
							
Lug Plate, Aft Crosstube							
<div><div><i>ES 10/06/08</i></div><div><i>10</i></div></div>							
	<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
	ST094		12				
	59343		12				
	ST095		11				
	58344		11				
D3908-3	Manufactured	No	100	Each	3.0000	1	5
							
Stud Receiver, Lower							
<div><div><i>N</i></div><div><i>A</i></div><div><i>mf 10-6-9</i></div></div>							
	<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
	ST095		3				
	57816		2				
	58849		1				
D3908-5	Manufactured	No	100	Each	9.0000	1	5
							
Eyebolt Stud							
<div><div><i>N</i></div><div><i>A</i></div><div><i>mf 10-6-9</i></div></div>							
	<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
	GA		1				
	57428		1				
	ST095		8				
	58850		8				

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As per Rev B 10-04-06 VERIFIED BY:DD
10.05.27 DD verf:EC
10.05.28 DD verf:EC



Start Date: 6/7/2010

Required Date: 6/9/2010

Start Qty: 5.00

Required Qty: 5.00

D3910-1



Crosstube Lug

Manufactured No

100

Each

9.0000

1

5

Location

Loc Qty

Loc Code

st507

9

58341

9

D4091-1



Mounting Lug

Manufactured No

100

Each

1.0000

1

5

Location

Loc Qty

Loc Code

ST460

1

58098

1

AN3C12A



Bolts

Purchased No

100

Each

126.0000

2

10

Location

Loc Qty

Loc Code

ST351

126

112314

76

114761

50

AN4C13A



BOLT

Purchased No

100

Each

131.0000

1

5

Location

Loc Qty

Loc Code

ST357

131

113359

20

114108

11

114442

50

114615

50

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Shop Packet Print

Page 2

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10.05.27 DD verf:EC
10.05.28 DD verf:EC
IPP REV B:
IPP Rev:C as per PC1
IPP Rev:D per ECN10-581

Start Date: 6/7/2010

Required Date: 6/9/2010

Start Qty: 5.00

Required Qty: 5.00

MS17984-C413

Purchased

No

100

Each

19.0000

1

5



PIN, QUICK RELEASE

N

MF 10-6-9

Location

Loc Qty

Loc Code

ST297

4

114340

4

ST314

15

114523

1

114774

14

4M18

MS20615-4M20

Purchased

No

100

Each

273.0000

6

30



RIVET

M114506 (30x)

ES 10/06/08

Location

Loc Qty

Loc Code

ST323

273

113254

7

114324

4

114349

62

114808

200

MS21043-3

Purchased

No

100

Each

3,417.000

2

10



Nut

N

A

MF 10-6-9

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

3341

112314

3341

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Page 3

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10.05.27 DD verf:EC
10.05.28 DD verf:EC

IPP REVB:

IPP Rev:C as per PC1

IPP Rev:D per ECN10-581

Start Date: 6/7/2010

Required Date: 6/9/2010

Start Qty: 5.00

Required Qty: 5.00

MS21043-4

Purchased

No

100

Each

1,595.000

1

5



Nut

Location

Loc Qty

Loc Code

FG	40	
104603	40	
ST301	1555	
112492	25	
113069	8	
114181	222	5
114348	500	
114523	500	
114784	300	

NAS1149C0332R

Purchased

No

100

Each

1,198.000

4

20



Washer

Location

Loc Qty

Loc Code

ST297	1198	
113524	10	
113737	150	
114341	1038	

NAS1149C0432R

Purchased

No

100

Each

762.0000

2

10



Washer

Location

Loc Qty

Loc Code

ST297	762	
114292	162	
114742	600	

Monday, June 07, 2010 10:30:48 AM

Shop Packet Print

Page 4

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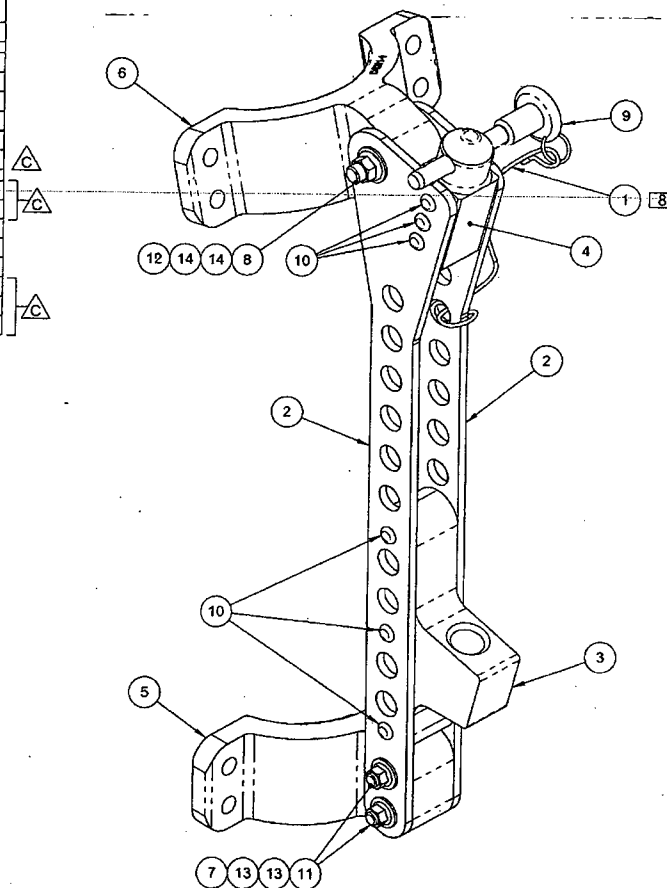
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ITEM	QTY.	P/N	DESCRIPTION
	X	D3908-041	X-TUBE LUG ASSY (AFT)
1	1	D2690-6	LANYARD
2	2	D3908-1	AFT X-TUBE LUG PLATE
3	1	D3908-3	STUD RECEIVER LOWER
4	1	D3908-5	EYEBOLT STUD
5	1	D3910-1	X-TUBE LUG
6	1	D4091-1	MOUNTING LUG
7	2	AN3C12A	BOLT
8	1	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	6	MS20615-4M20	RIVET
11	2	MS21043-3	NUT
12	1	MS21043-4	NUT
13	4	NAS1149C0332R	WASHER
14	2	NAS1149C0432R	WASHER



D3908-041 X-TUBE LUG ASSY (AFT)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3908-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.34 lbs
- 8) ATTACH TO D3908-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING.

C	REDESIGNED ITEM #2: ITEM#6 REPLACES QTY 1 ITEM#5; QTY 2 FOR ITEMS #7 & 11 WAS QTY 4, QTY 8 FOR ITEM #13 WAS 4, ADDED ITEMS #8, 12 & 14	MB	10.05.27
B	BOM: D3908-5 REPLACED WITH D3908-5, QTY 1 ADDED: D2690-6 & MS17984-C413, SHEET 5: ADDED D3908-5	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.05.27		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3908	REV. C SHEET 1 OF 5
TITLE X-TUBE LUG ASSY (AFT)	SCALE NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

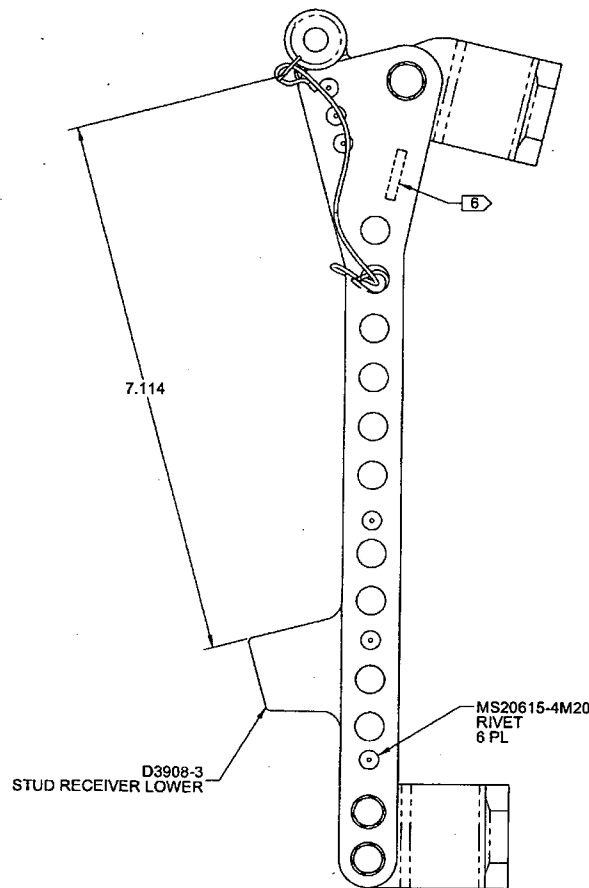
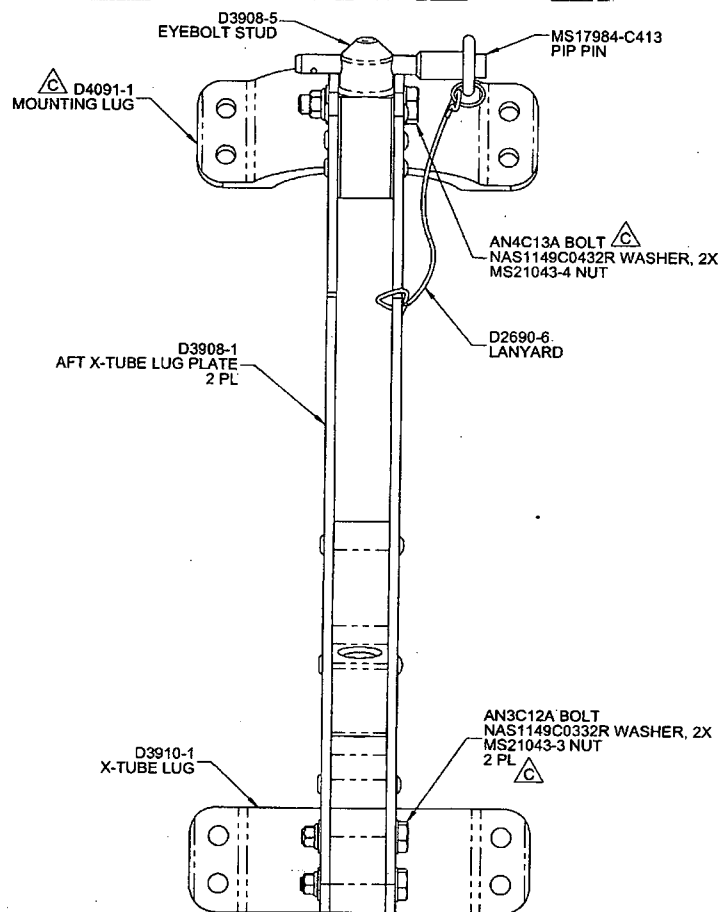
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



#59530

RELEASED
 2010-05-28
 JNP

D3908-041 X-TUBE LUG ASSY (AFT)

DESIGN	JFH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG ASSY (AFT)	NTS
DATE	10.05.27	<small> COPYRIGHT © 2010 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. </small>	

8 7 6 5 4 3 2 1

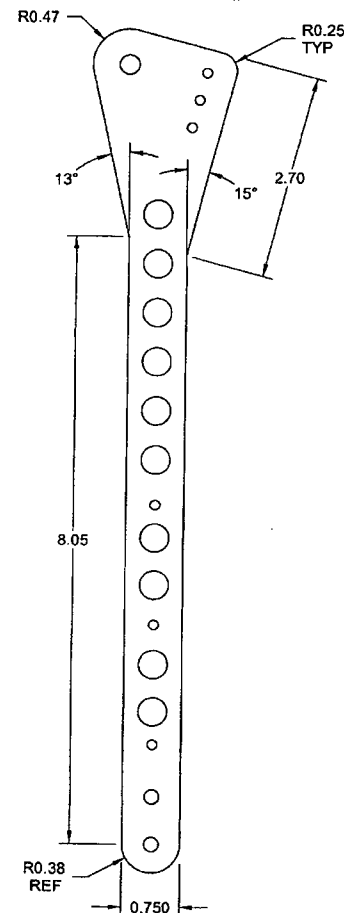
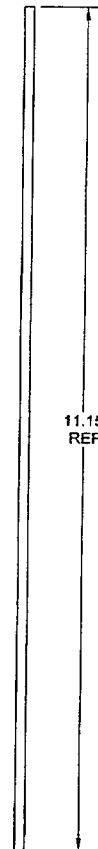
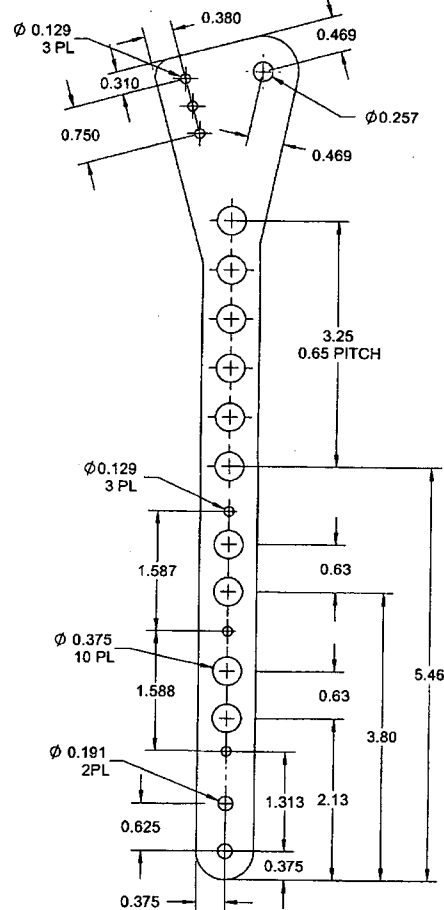
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NOTE: Date & initial all entries





#54500

RELEASED
2010-05-28
MND

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.31 lbs

D3908-1 AFT X-TUBE LUG PLATE

DESIGN	JFH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG ASSY (AFT)	NTS
DATE	10.05.27	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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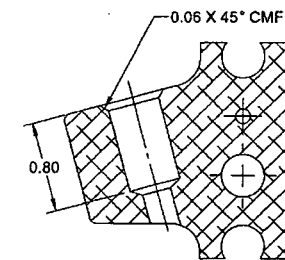
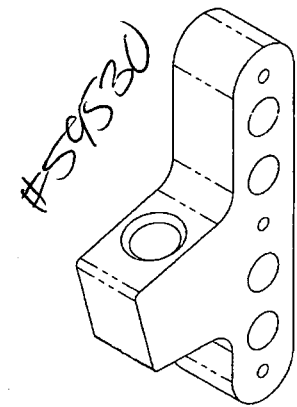
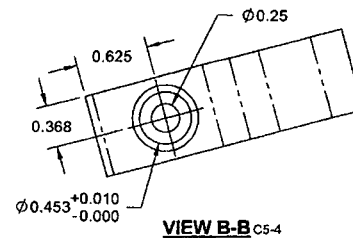
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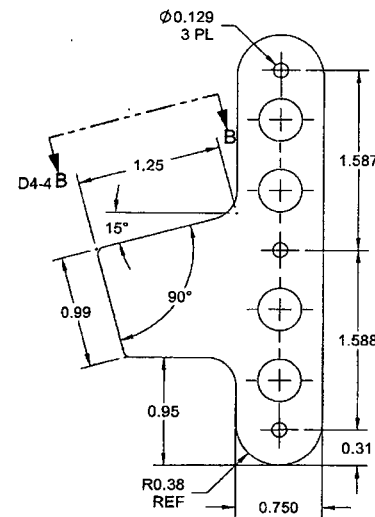
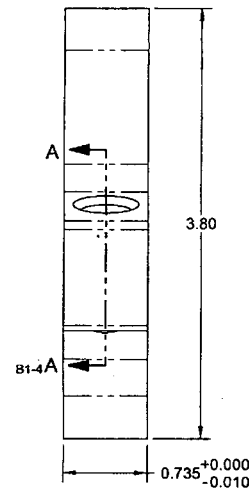
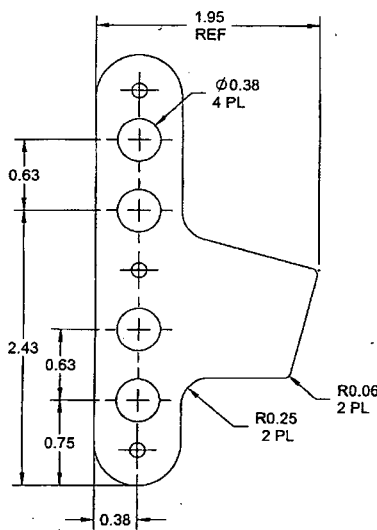
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SECTION A-A B6-4





D3908-3 STUD RECEIVER LOWER

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.69 lbs

RELEASED
2010-05-28

DESIGN	JFH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG ASSY (AFT)	NTS
DATE	10.05.27	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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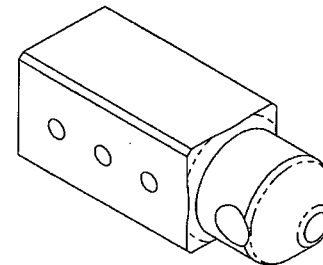
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			






NOTE: Date & initial all entries



59530

RELEASED
2010-05-28
MP

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.26 lbs

DESIGN	JFH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG APPR.		D3908	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG ASSY (AFT)	NTS
DATE	10.05.27	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN CONSENT FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries